

Work Order ID 84362

May-10-12 2:33:28 PM

84362

Page 1

Item ID: D4062-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Support Assembly

Start Date: 10/05/2012 Start Qty: 4.00

4 /
4 /

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/10 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4062	C

100	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

100

Packaging Memo

Packaging

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110

Small Fab Memo

Small Fab

ASSEMBLE AS PER DWG

BOND AS PER NOTE #8

Pro seal B# 12/287

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC Memo

Quality Control

0.00

8/26/05

276608

1 0 ll
12.06.04

Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84362

May-10-12 2:33:28 PM

84362

Page 2

Item ID: D4062-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Support Assembly
 Start Date: 10/05/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 24/05/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WNA</u>	0.00							
130									
Packaging	Memo	0.00				1	0		12.06.04
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							PB ⇒
140									12/6/11
QC	Memo	0.00							
Quality Control									

75332

W/O: 84362		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4062-041 PAR #: _____ Fault Category: hose fab / oc inspector NCR: Yes No DQA: Int R Date: 12/06/11
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/6/12

NCR: 12-1497		WORK ORDER NON-CONFORMANCE (NCR) 412.09						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/05	#130	Found when doing wo. that D4062-1 was not at the correct Rev. After closely inspecting Part Found it was not correct and didn't fit right.	S 05/04/12 12/06/05	Scrap D4062-1 and replace B874369 3 12/980 B 85235	12.06.06	S 12/06/06	S 05/04/12 12/06/05	S 12/06/05
		RC wrong Rev of Part in Place and missing all inspection	S 05/04/12 12/06/05	Find out why old incorrect Rev of Part was in welding Booth + Re-train inspectors to look closely + Better when inspecting Part.	Part was 3.8 with no holes 12/06/05	S 12/06/06	S 12/06/05 05/04/12	S 12/06/05
				New Jig To replace old Jig J.T. 9810				

NOTE: Date & initial all entries

Picklist Print

May-10-12 2:33:31 PM

Page 1

Work Order ID: 84362

84362

Parent Item: D4062-041

D4062-041

Parent Item Name: Tank Support Assembly

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV:A NEW ISSUE 11-11-23 JLM VERIFIED BY:DD

IPP

REV:B AS PER REV C 12-03-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4062-1 *D4062-1* Upper Tank Support		Manufactured	No		B84369 377532 = 1		Each	0.0000	**	4		12.06.04	
D4062-3 *D4062-3* Lower Tank Support		Manufactured	No		B84370 = ①		Each	0.0000	**	4		12.06.04	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

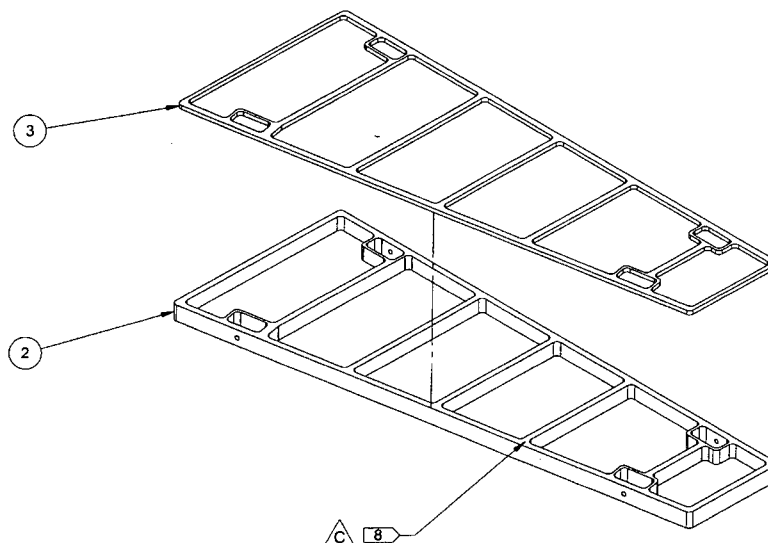
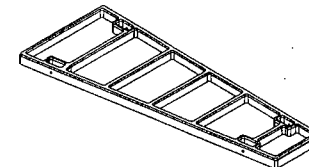
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4062-041	TANK SUPPORT ASSEMBLY
2	1	D4062-1	LOWER TANK SUPPORT
3	1	D4062-3	UPPER TANK SUPPORT



D4062-041 TANK SUPPORT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.91 lbs
- 8) BOND ITEMS 2 & 3 TOGETHER USING PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 84362 MLJ
12/05/10

2012-03-02

C	REMOVE HARDWARE TO ATTACH ITEMS 2 & 3. REMOVE C'BORE.	DC	11.12.14
B	MODIFIED DIMS & DESIGN OF -1, ADDED -3/-041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>SC</i>		
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>		
MFG. APPR.	<i>SC</i>		
APPROVED	<i>SC</i>		
DE APPR.	<i>SC</i>		
DATE	11.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4062** REV. C
SHEET 1 OF 3
TITLE **TANK SUPPORT** SCALE NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

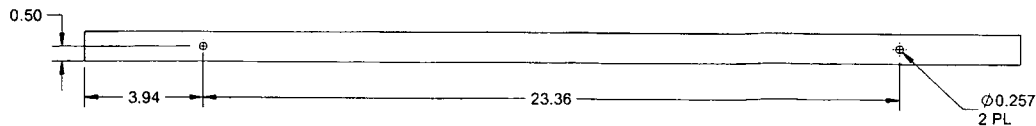
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

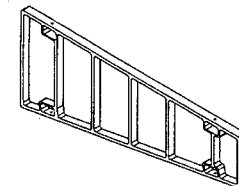
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

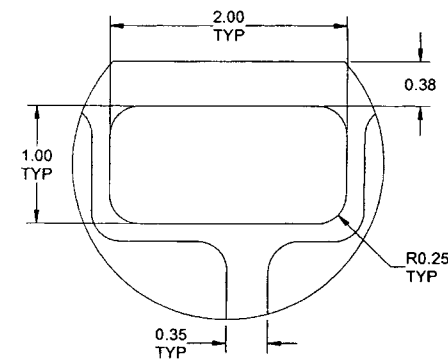
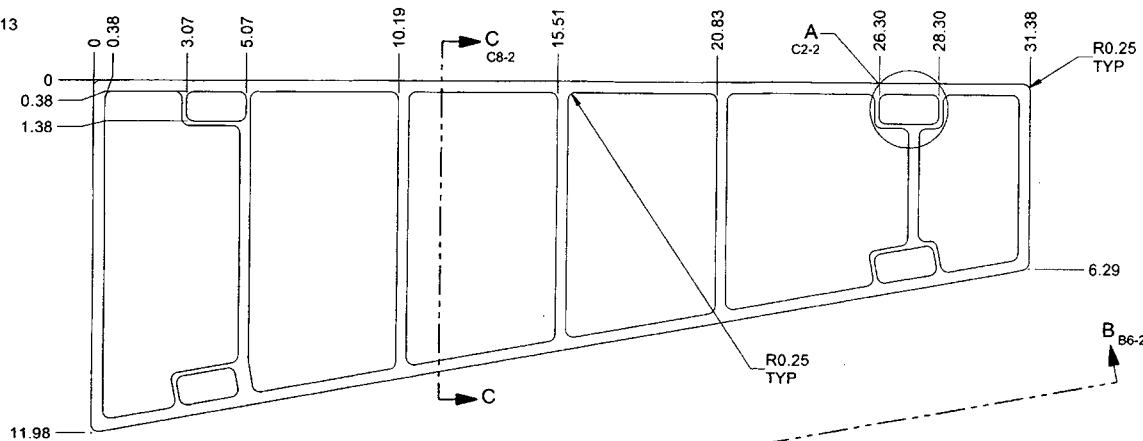
NOTE: Date & initial all entries



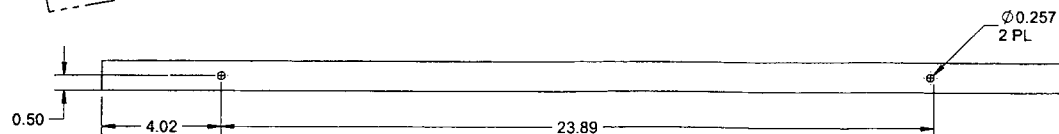
84362



SECTION C-C
C6-2



DETAIL A
SCALE 4X
C4-2



VIEW B-B
B5-2

NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMWB10
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.53 lbs
- 8) CUT PER D4062-1.DXF
- 9) MAXIMUM INSIDE RADIUS = 0.250

D4062-1 LOWER TANK SUPPORT

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4062	SHEET 2 OF 3
APPROVED	149	TITLE	SCALE
DE APPR.		TANK SUPPORT	NTS
DATE	11.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
2012-03-02
MP

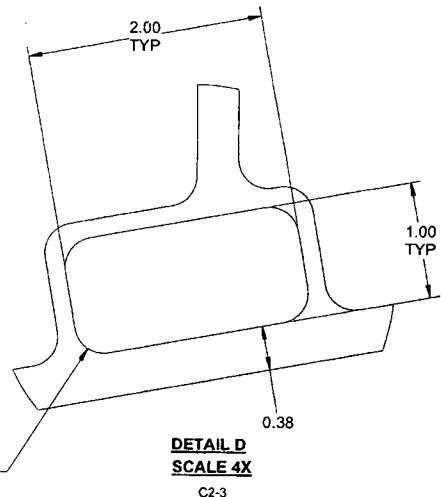
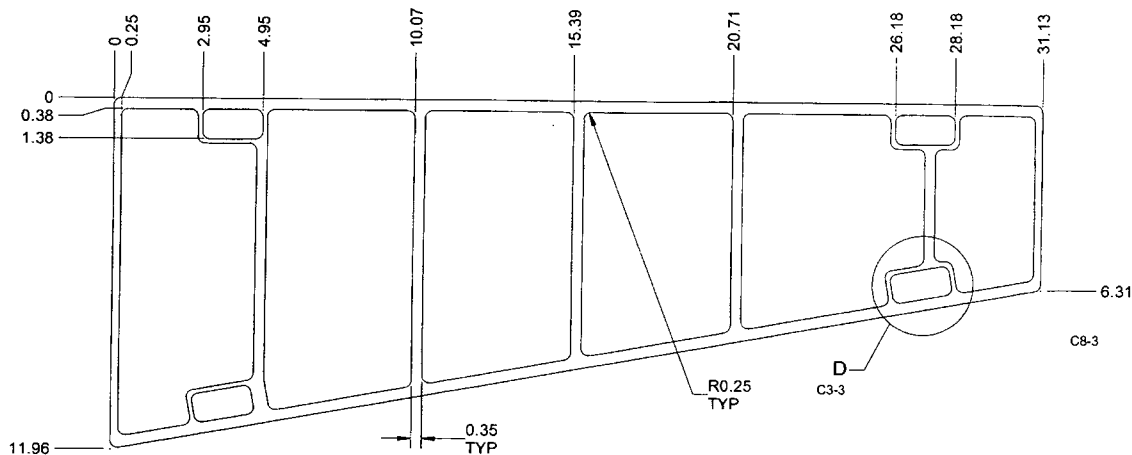
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4062-3 UPPER TANK SUPPORT

NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 0.25 THICK
REF DART SPEC MUHMWB025
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs
- 8) CUT PER D4062-3.DXF

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4062	SHEET 3 OF 3
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	TANK SUPPORT	NTS
DATE	11.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
2012-03-02
NW

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries